

Date: Tuesday, 16/09/2008 3:26:59 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: DUAL MIRROR ASSEMBLY
<b>Job Number</b>	: 42035		
<b>Estimate Number</b>	: 12278		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D206558043
<b>This Issue</b>	: 16/09/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: IIN206-558 <i>UR</i> <i>E</i>
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 39518	<b>Drawing Revision</b>	: C <i>UR</i>
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 05/10/2008
<b>Checked &amp; Approved By</b>	: <i>JLD 08.9.16</i>	<b>Qty:</b>	5 Um: Each
<b>Comment</b>	Est. G 02.09.19 Re-format; Incorporated D2066 KJ Est Rev:H 08-05-14 now @ chg006/ add D3778-1 per ECN1171 DD verified: Est Rev:I 08-08-19 now @ chg 007 DD verified by:ec		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL


*Sostu/25*
*CHG 006*

*AJ Co JLD*
*08.10.01*
*08.11.25*

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-558-043 CHG007

*08/11/04*

2.0

D2011101

6" Mirror



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Mirror 6"

Pick:

Qty Part Number

Description

Batch

2 D2011-101

Mirror Ass'y 6"

*B43235*
*50P*

3.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- assemble as per dwg D206-558

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL MIRROR ASSEMBLY

Job Number: 42035

Part Number: D206558043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	D2053	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

Pick: Packing Kit

Qty Part Number Description Batch

1 D2053 Bracket B334531

50

7.0	D37781	Bracket
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

batch: B41958

50

8.0	D2067	Connector
-----	-------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Connector

Pick: Packing Kit

Qty Part Number Description Batch

1 D2067 Connector B39558

50

9.0	D2071	Cable Assembly
-----	-------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Cable Assembly

Pick: Packing Kit

Qty Part Number Description Batch

1 D2071 Cable B39559

50

10.0	AN34A	Bolt
------	-------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description Batch

4 AN3-4A Bolt M103641

8/11/24

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL MIRROR ASSEMBLY

Job Number: 42035

Part Number: D206558043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

11.0	AN5261032R9	Screw
------	-------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Screw

Pick: Packing Kit

Qty Part Number Description Batch

4 AN526-1032R9 Screw M101189

or AN526C1032R9

12.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description Batch

6 AN960JD10L Washer M105793

or AN960C1032R9

13.0	MS21919DG5	Clamp
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Clamp

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21919DG5 Clamp M107012

or MS21919WDG5

14.0	MS354899	Grommet
------	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Grommet

Pick: Packing Kit

Qty Part Number Description Batch

1 MS35489-9 Grommet M9619

15.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Nut

batch: M109031

8/11/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: DUAL MIRROR ASSEMBLY

Job Number: 42035

Part Number: D206558043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Sosulzy (H)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-558,043

Location: \_\_\_\_\_

PPP Rev: H

8/11/25

MS

SP

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26

Job Completion



MF 08-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

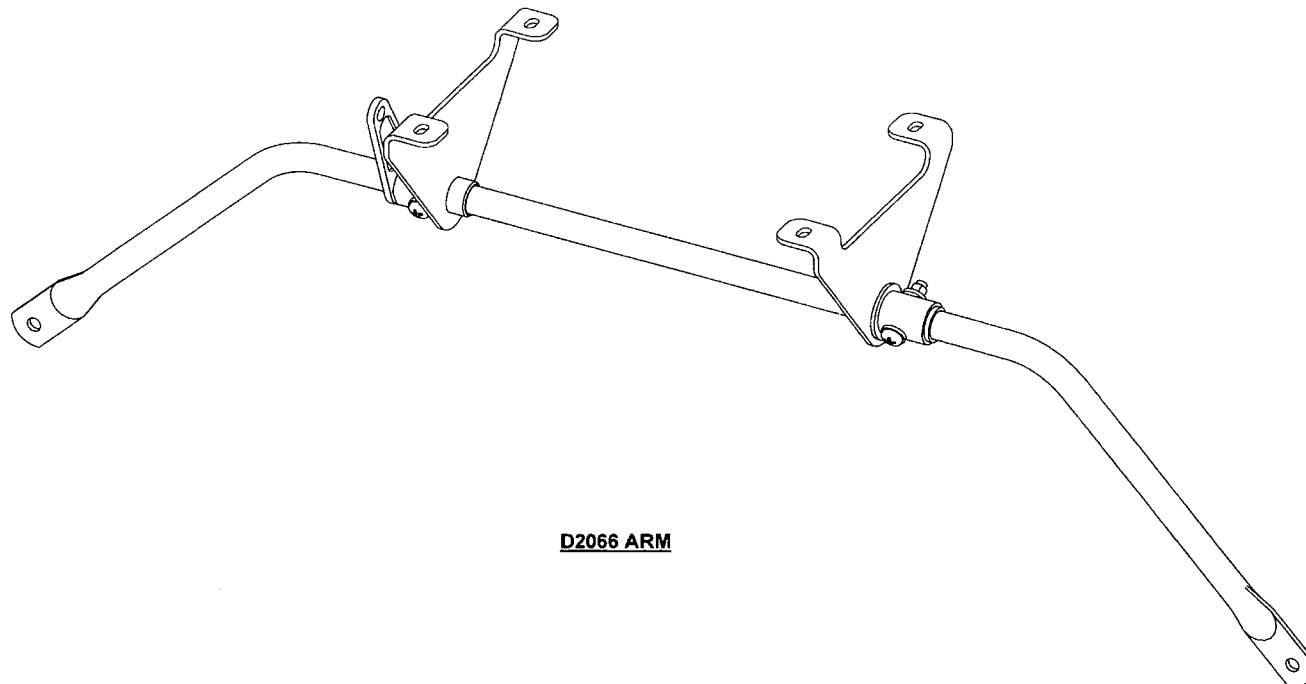
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D2066 ARM**

**RELEASED**  
08.07.12

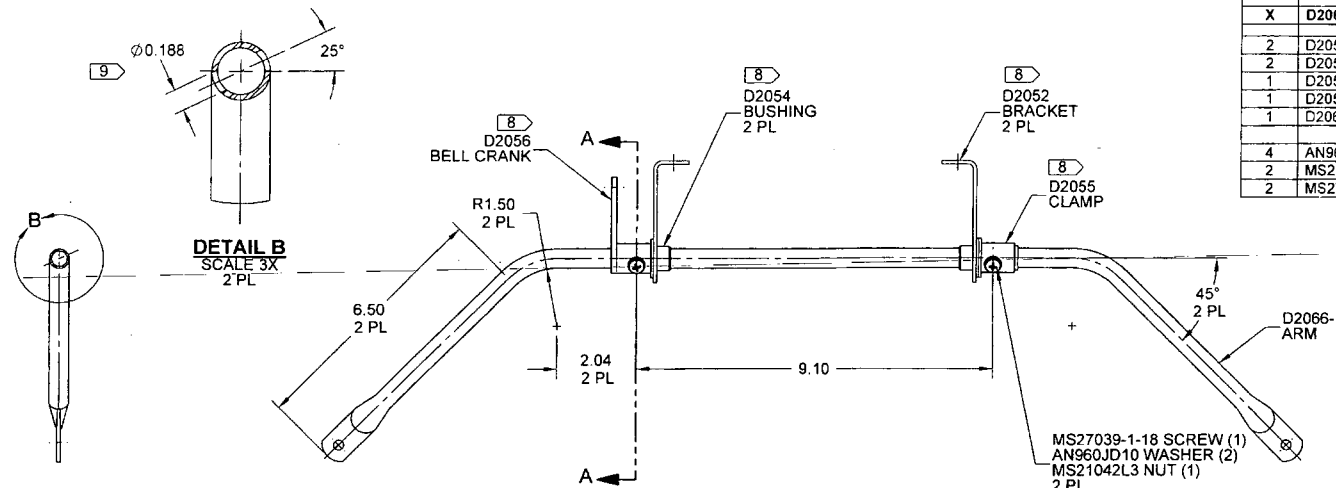
- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.85 lbs

C	REDESIGNED	PH	08.06.12
B	NEW ISSUE	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D2066</b> TITLE <b>ARM</b> SCALE <b>NTS</b> COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	FW		
CHECKED	JS		
MFG. APPR.	JS		
APPROVED	JS		
DE APPR.	JS	REV. C SHEET 1 OF 2	
DATE	08.06.12		

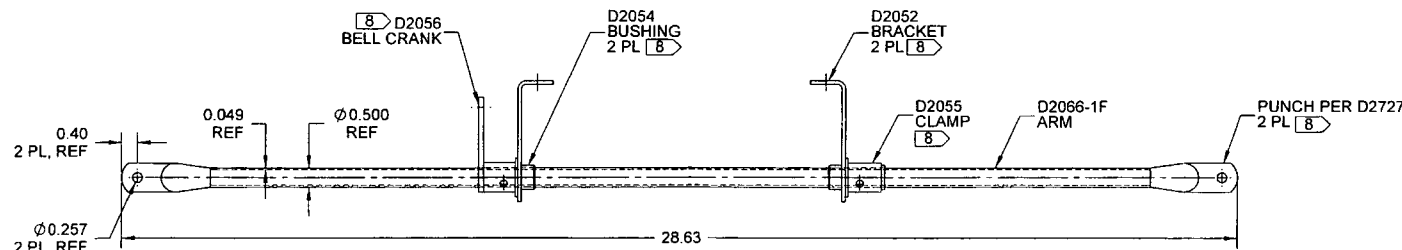
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**WITHOUT NOTICE**  
**WORK ORDER**  
**NO. 40024**

8 7 6 5 4 3 2 1

QTY	P/N	DESCRIPTION
X	D2066	ARM
2	D2052	BRACKET
2	D2054	BUSHING
1	D2055	CLAMP
1	D2056	BELL CRANK
1	D2066-1	ARM
4	AN960JD10	WASHER
2	MS21042L3	NUT
2	MS27039-1-18	SCREW



**D2066-1 ARM BENDING DETAIL** (MAKE FROM D2066-1F)



**D2066-1F ARM CUT LENGTH DETAIL**

RELEASED  
28-07-23-18

**NOTES:**

- 1) MATERIAL: D2066-1F: AISI 304/316 SS SEAMLESS ROUND TUBING,  $\phi 0.500 \times 0.049$  WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2066-1 = 0.62 lbs (SEE SHEET 1 FOR ASSEMBLY WEIGHT)
- 8) BEFORE BENDING: ADD D2052 BRACKETS, D2054 BUSHINGS, D2055 CLAMP AND D2056 BELL CRANK TO D2066-1 ARM AFTER FIRST END OF D2066-1 IS PUNCHED AND BEFORE SECOND END OF D2066-1 IS PUNCHED
- 9) DRILL 0.188 AFTER BENDING

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PL	DRAWING NO. <b>D2066</b>	REV. C SHEET 2 OF 2
CHECKED	JS	TITLE <b>ARM</b>	SCALE NTS
MFG. APPR.	JS	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
APPROVED	JS	DATE <b>08.06.12</b>	
DE APPR.	JS		

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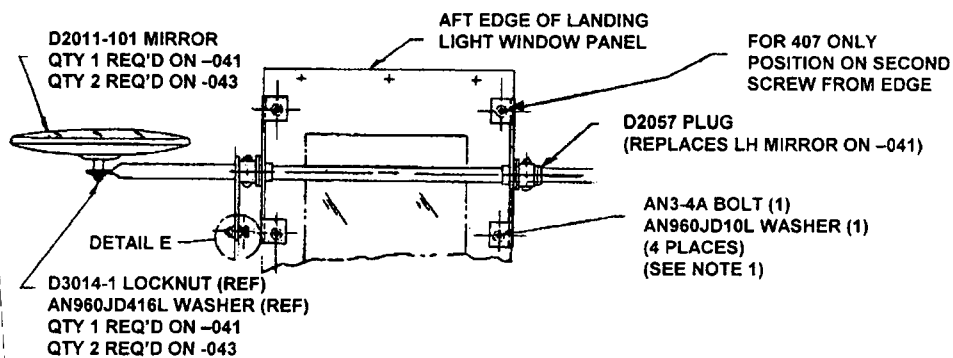


Figure 3: - View C: Looking Down on Mirror Installation  
(D206-558-041 Mirror Shown)

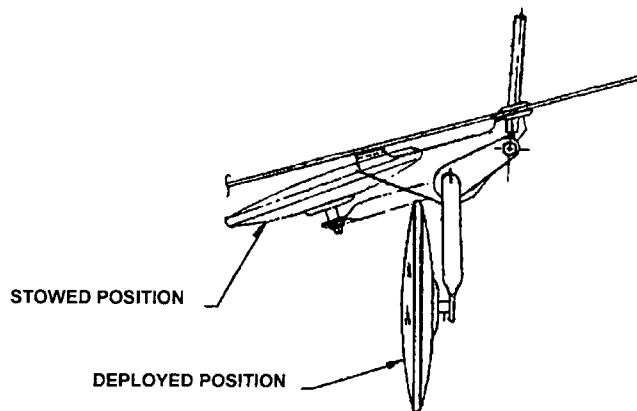


Figure 4: - Detail D: Looking from Side on Mirror Installation  
(D206-558-041/-043 Mirror Shown)

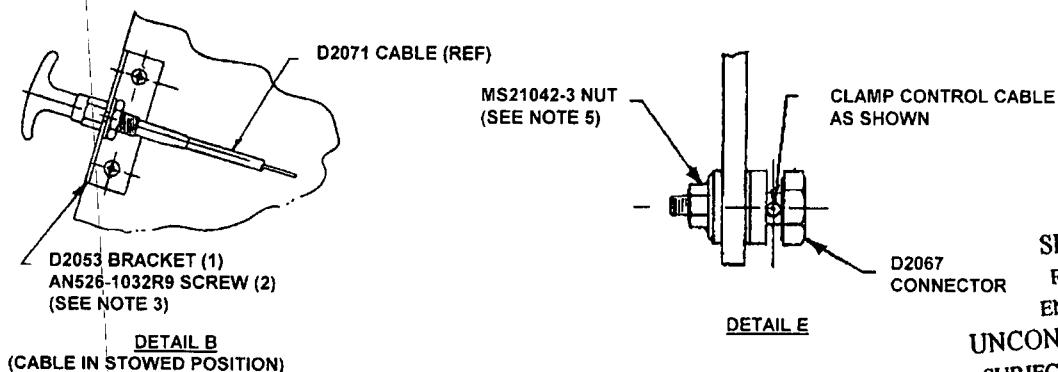


Figure 5: - Details B and E on Mirror Installation  
(D206-558-041/-043 Mirror Shown)

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Revision: C  
Date: 01.10.03

## 4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041 Bell 206A/B/L/L1/L3/L4 Bell 407	2.4 lb 1.09 Kg	+5.0 in +0.13 m	+12.0 in-lb +0.14 m-Kg	+14.8 in +0.38 m	+35.5 in-lb +0.41 m-Kg
D206-558-043 Bell 206A/B/L/L1/L3/L4 Bell 407	3.0 lb 1.36 Kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-Kg	+14.8 in +0.38 m	+44.4 in-lb +0.52 m-Kg

## 5.0 WEIGHT AND BALANCE

Qty -041	Qty -043	Part Number	Description
X		D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X	D206-558-043	DUAL CARGO MIRROR ASSEMBLY
1	2	D3014-1	* LOCKNUT
1	1	D2071	CABLE ASSEMBLY
2	2	D2054	BUSHING
1	1	D2067	CONNECTOR
	1	D2066	ARM
1		D2065	ARM
1		D2057	PLUG
1	1	D2056	BELLCRANK ASSEMBLY
1	1	D2055	CLAMP
1	1	D2053	BRACKET
2	2	D2052	BRACKET
1	2	D2011-101	MIRROR ASSEMBLY
4	4	AN3-4A	BOLT
4	4	AN526-1032R9	SCREW
1	2	AN960JD416L	* WASHER
4	4	AN960JD10	WASHER
6	6	AN960JD10L	WASHER
3	3	MS21042-3	NUT (or MS21042L3)
2	2	MS21919DG5	CLAMP
2	2	MS27039-1-18	SCREW
1	1	MS35489-9	GROMMET

\* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

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Revision: C

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